



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

269T9319-2
Job Sheet 175340



Part No: 269T9319-2

Job Qty: 4 ea

Part Name: Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/3/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 4/16/18

Description:

Type: SOLD

Note: DWG 269T9319 Rev 2 IPP Rev A 18.04.02 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/14/18	0.00	0.00	Start Up Machining-4		J.C.-V
120	Lathe Conv	4 pcs		4/16/18	0.50	0.33	Lathe Conv-2		J.C.-V
130	QC	4 pcs		4/16/18	0.00	0.00	QC2 Machining-5		J.C.-V 18-04-18
140	QC	4 pcs		4/16/18	0.00	0.00	QC8 Machining-5		KA 18-04-18
150	Outsource	4 pcs		4/16/18	0.00	0.00	Outsource13		
160	Packaging	4 pcs		4/16/18	0.00	0.00	Packaging2		
170	QC	4 pcs		4/16/18	0.00	0.00	QC6		
180	Packaging	4 pcs		4/16/18	0.00	0.00	Packaging3-2		18-04-23
190	QC21-SA	4 Ea		4/16/18	0.00	0.00	QC21		GA083

Part Op 120 - Machine as per DWG.

Descriptions: 150 - Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of
Conformity is required
160 - Receive
180 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R0.250	Tool Steel Round Bar 0.250 dia.	.7320 ft (.183 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-O1-R0.250	1	23	0

Part Specifications

Specifications could not be found.

Plex 4/18/18 10:27 AM dart.logan.david



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Container No: S062596



Part: 269T9319-2

Job No: 175340

Serial No/Batch: S062596

Revision: 2

Inspector:

Date: 04/18/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

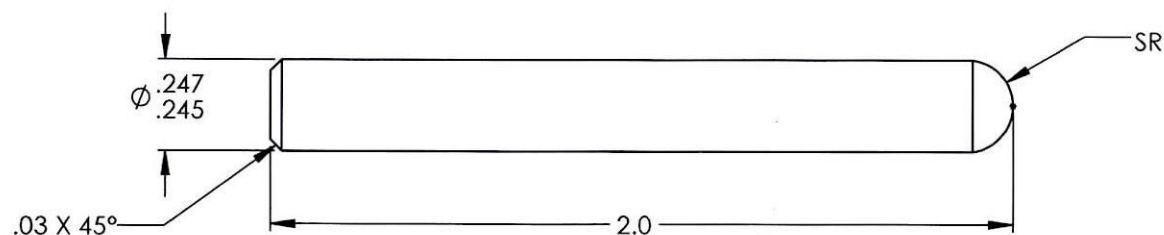
Work Order update only ☐

Work Order: <u>175340</u> Part No. <u>269T9319-2</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval April 17, 2018																			
Description Work Order Deviation				Disposition																					
- 269T9319-2 can be manufactured from 17-4PH-H900 as an alternative material - Black Zinc plate is not required if the part is manufactured from SS				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																					

Root Cause				FAULT CATEGORY			
Environment ☐			No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐			Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐			Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐			Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐			Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☒			Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐			Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐			Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐			Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐			Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐			Manufacturing Process ☐	OTHER : _____			
Misidentified ☐		☒	Past Due ☐				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0124	-2 ADDED FINISH SPEC BLACK ZINC ASTM B633 TYPE II SC 2.	8/18/2016	DEW	JAG



-2
PIN

DART AEROSPACE	
TITLE T/R BUSHING WRENCH	
DWG NO. 269T9319-2	REV 2
MAT'L 01	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK ZINC	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE II SC 2	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 2:1	DATE 6/24/2005
	SHEET 3 OF 3

